

Date: Thursday, 27/11/2008 2:09:37 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW INSTALLATION
Job Number	: 42790		
Estimate Number	: 13622		
P.O. Number	:	Part Number	: D600572015
This Issue	: 27/11/2008 S.O. No. :	Drawing Number	: IIN D600-572 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 22/10/2008 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>JL 08.11.27</u>	Due Date	: 10/11/2008 Qty: 3 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:B Reformat,incorporated D2996 KJ/RF 03-06-02		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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AA for JLD 08/11/10



Comment: Photocopy bluefile & type labels per PPP D600-572-015 CHG 002

S order 27

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch Number

JL 08.11.27

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 5.6839 sf(s)/Unit Total : 17.0516 sf(s)
 UHMW 1" Black
 Batch: 109186 IB 8-12-3

(6)

4.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 cut blank

IB 8-12-3

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Ph →
Last Page

1-Inspect for surface damage

2- Mill as per Folio FA120 Rev: AA & Dwg D2996 Rev: A

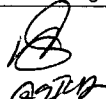
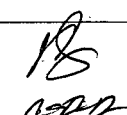
3-Deburr per dwg D2996

JL 09/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D600-572-015 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42790</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/12	5	- programme development - testing new pgm * wrong path # engraved on part	 09/01/12	Re engraver correct P/A# → ensure pin to check B* + P/A# before running	J.H 09/01/12	S 09/01/12	 09/01/12	S 09/01/12

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 42790

Part Number: D600572015

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		J.L. 09/01/12
7.0	QC8	SECOND CHECK
Comment: SECOND CHECK		J.F. 09/01/16 (4)
8.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
9.0	D2182B	Rubber Cushion
Comment: Qty.: 2.1053 f(s)/Unit Total : 6.3158 f(s) Rubber Cushion 6" long x4 batch: 42737		LU
10.0	D2274	Radius Block
Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s) Radius Block BATCH: 42099		LU
11.0	D2519	Clamp
Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s) Clamp BATCH: 41430 X 42407 SP		LU
12.0	D2529	Washer
Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s) Washer BATCH: B42408		LU
13.0	AN413A	Bolt
Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s) Bolt BATCH: M109285		LU 09/01/21 (3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 42790

Part Number: D600572015

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

BATCH: M109249

15.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

BATCH: M109282

16.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Clamp

BATCH: M109556

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D600-572-015

Location: _____

PPP Rev: _____

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-01-23

DART AEROSPACE LTD		Work Order: 42790
Description: bearing		Part Number: A2996
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	.06X45°	+ .030	.07X45°	✓			
B	.625	+ .030	.627	✓			
C	.250	+ .010	.252	✓			
D	1.25	+ .030	1.250	✓			
E	5.86	+ .030	5.862	✓			
F	.25X45°	+ .030	.270X45°	✓			
G	.950	+ .030 - .010	.958	✓			
H	.433	+ .010	.435	✓			
I	19.00	+ .030	19.00	✓			
J	3.63	+ .030	3.625	✓			
K	4.540	+ .010	4.542	✓			
L	19.34	+ .030	19.34	✓			
M	Ø.260	+ .005 - .001	.260	✓			
N	.930	+ .030	.925	✓			
O	.300	+ .030 - 0	.310	✓			
P	.37	+ .030	.377	✓			
Q	2.49	+ .030	2.485	✓			
R	.38	+ .030	.377	✓			
S							

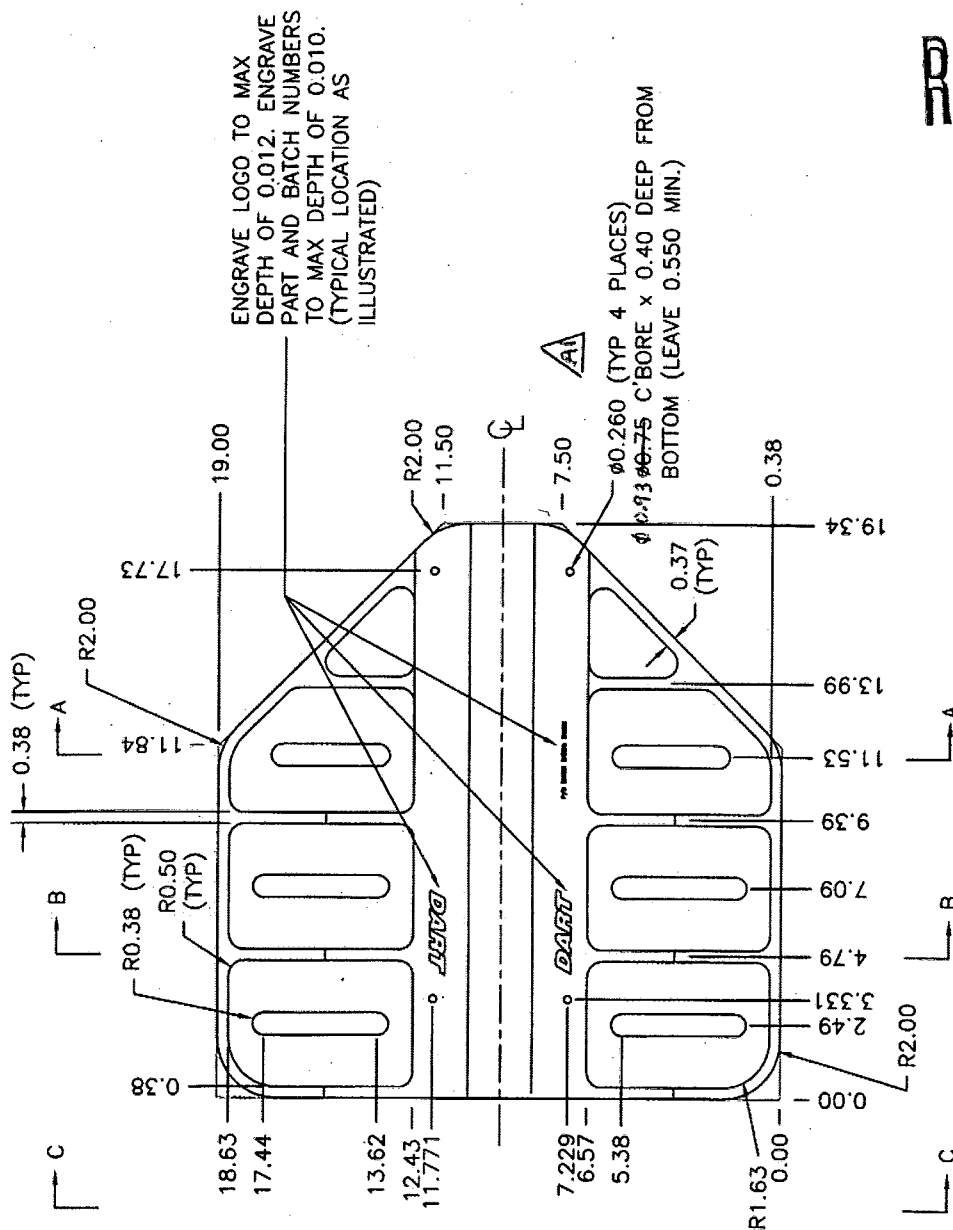
Measured by: J.L.	Audited by: J.F.	Prototype Approval: N/A
Date: 09/01/12	Date: 04/01/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2996	REV. A SHEET 1 OF 2
DATE 01.02.23				TITLE BEARPAW	SCALE 1:6
A	01.02.23			NEW ISSUE	
A1	# 03.01.13			# 0.93 WAS 0.75	

RELEASED
01.03.14 #



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WITHOUT NOTICE
WORK ORDER
NO. 42790

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

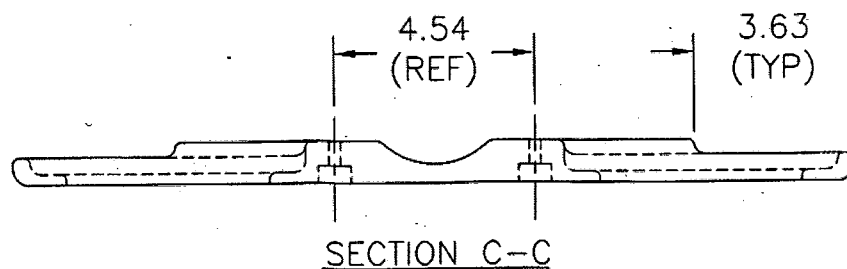
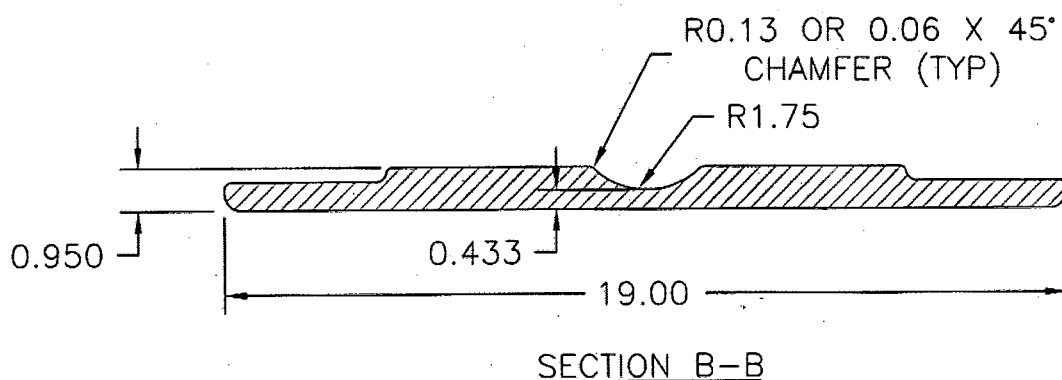
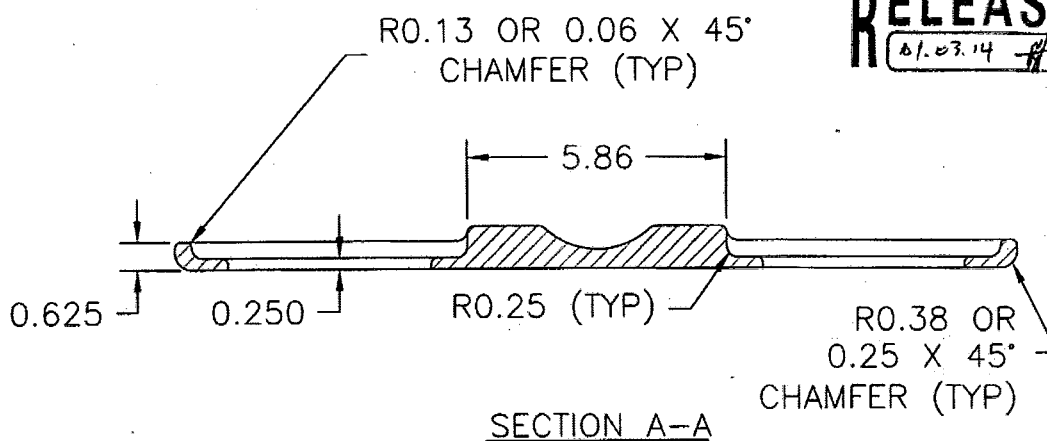
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2996	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 #



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